

Date: Tuesday, 22/07/2008 11:27:12 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 40713		
Estimate Number	: 13490		
P.O. Number	:	Part Number	: D37701
This Issue	: 22/07/2008 S.O. No. :	Drawing Number	: D3770 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	:	Material	:
Written By	:	Due Date	: 10/08/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUL 08.7.22</u>		
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 1.1926 f(s)/Unit Total: 14.3111 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M108019

FF 08-08-06

(12)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3770

2-drill holes thru to finish size as per dwg D3770

3- deburr



FF 08-08-06

FF 08-08-11

(13)

210

(13)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8/8/11 (x12)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

OK / m.h. 08/08/11

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/08/11

(x12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3770-1 PAR #: N/A Fault Category: Prod/Process ^{material} Small NCR: Yes No DQA: D Date: 08/08/08
 QA: N/C Closed: D Date: 08/08/12

NCR: <u>40713</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/08/06</u>	<u>2</u>	<u>D3770-1</u> Hole was drilled off center Part moved in vise on Drill Press R.C. Vise was not tight enough. Human error	<u>[Signature]</u>	<u>Hole of Live Human</u> <u>Scrap and replaced</u> <u>Qty 10 B# M108819</u>	<u>08/08/06</u> <u>FF</u>	<u>[Signature]</u> <u>08/08/06</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08/08/06</u>

NOTE: Date & initial all entries

Date: Tuesday, 22/07/2008 11:27:13 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 40713

Part Number: D37701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



50

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 135

8/8/11

(12)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

2008/08/12

mf 08-08-11

Job Completion



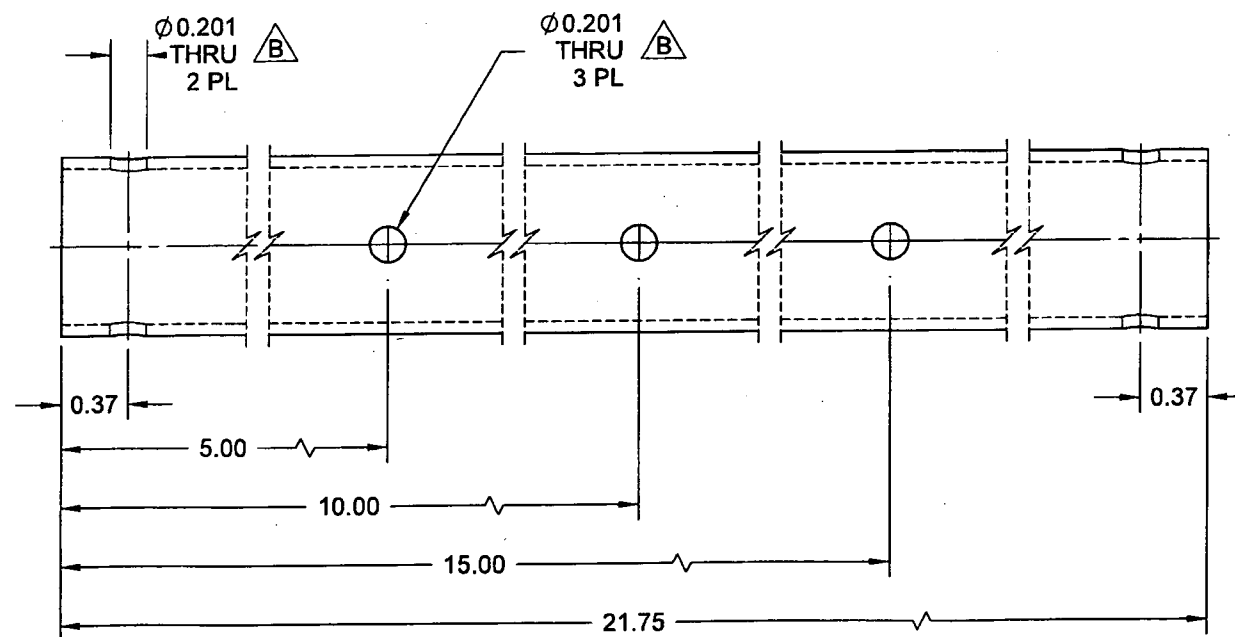
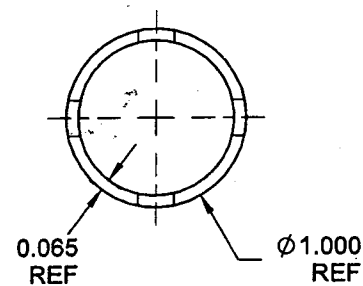
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3770-3 TUBE

RELEASED
08-07-10

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NO. 40713

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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PT	DRAWING NO.	REV. B
MFG. APPR.	MT	D3770	SHEET 3 OF 3
APPROVED	MT	TITLE	SCALE
DE APPR.	MT	TUBE	NTS
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8 7 6 5 4 3 2 1

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D

C

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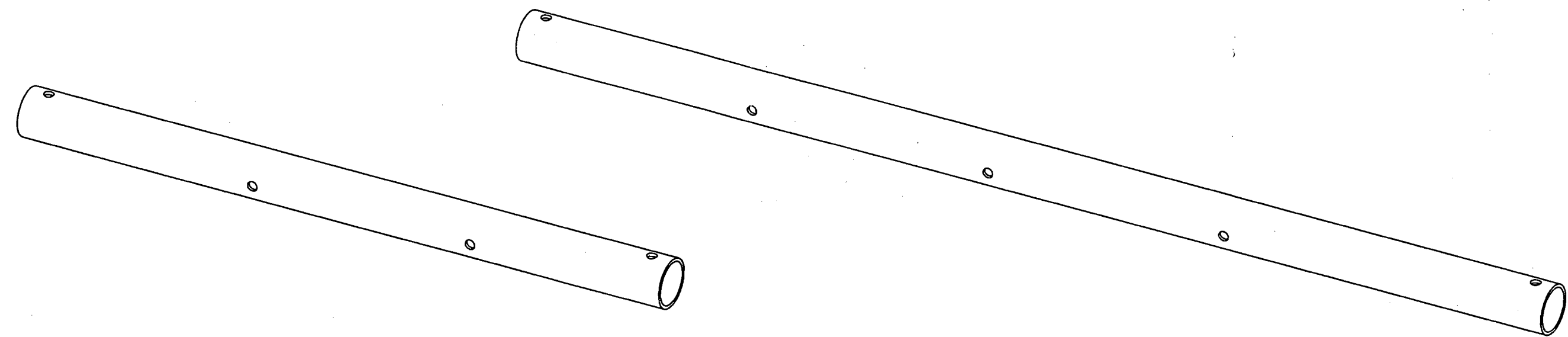
B

B

A

A

8 7 6 5 4 3 2 1



D3770-1 TUBE

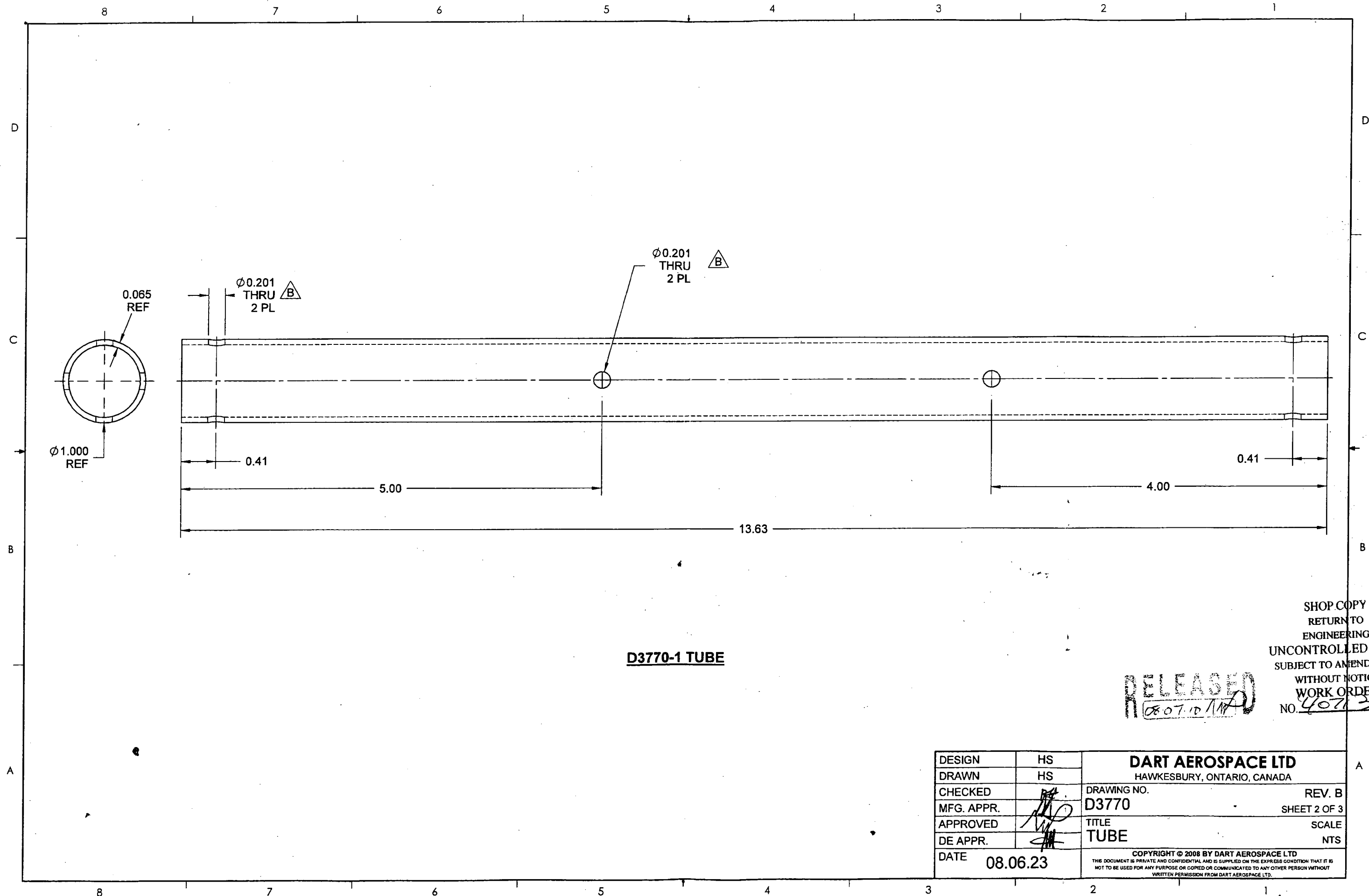
D3770-3 TUBE

- NOTES:**
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3770-1, 0.25 lbs
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>Per</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3770	SHEET 1 OF 3
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DE APPR.	<i>[Signature]</i>	TUBE	NTS
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NO. **46713**

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08.07.10



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WORK ORDER
NO. 40712

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CHECKED		DRAWING NO.	REV. B
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